

Date: Tuesday, 19/08/2008 4:04:13 PM
 *User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: WEARPAD	
Job Number	: 41036				Part Number	: D26483	
Estimate Number	: 10313				Drawing Number	: D2648 REV D	
P.O. Number	:				Project Number	: N/A	
This Issue	: 19/08/2008		S.O. No.	:	Drawing Revision	: D	
Prsht Rev.	: NC				Material	:	
First Issue	: / /		Type	: SMALL /MED FAB	Due Date	: 30/09/2008	
Previous Run	: 41123				Qty:	20 Um: Each	
Written By	:						
Checked & Approved By	: <u>JUL 08-8-19</u>						
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S16GA	1010/1025 sheet 16GA	
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 1.5750 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: <u>10S706 FB 8-9-11</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: <u>D</u> FB 8-9-11 Prog Rev: <u>D</u>	
		2-Deburr if necessary <u>FB 8-9-11</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>FB 8-9-11</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>S 08/09/11 X22 Counter</u>	
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		<u>SMALL & MEDIUM FAB RESOURCE 1</u>	
		Deburr if necessary <u>SMALL & MEDIUM FAB RESOURCE 1</u>	
		<u>Done at No 22</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SD 08/09/16 (22)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat M10755-3

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

(X 22)

EI 8-9-25

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



counts

Comment: VISUAL INSPECTION OF GROUND WELDS

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING

POWDER COATING



M 106442



(22X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8:15
8:15
0F

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320
8:45

M-1 08/09/26

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-26

(X 22)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-16

M-1

08/09/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 41436

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	414360
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

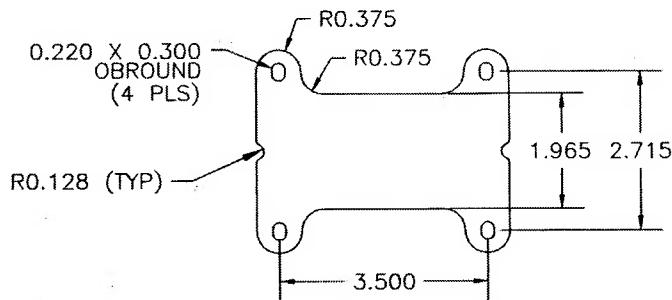
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

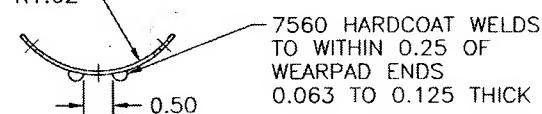
Measured by:	BB	Audited by:		Prototype Approval:	N/A
Date:	8-9-11	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	<i>[Signature]</i>

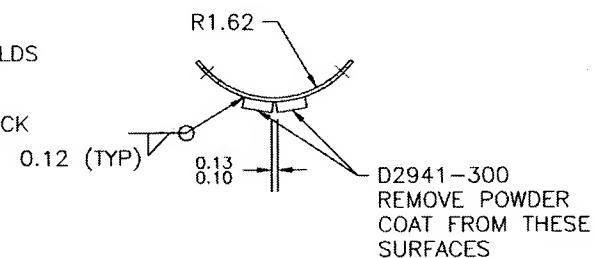
D2648-1 FLAT PATTERN



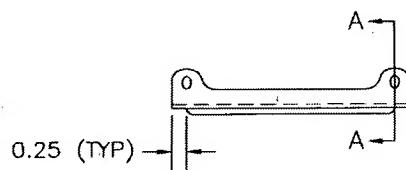
SECTION A-A



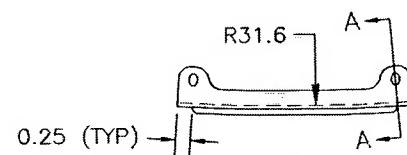
SECTION B-B



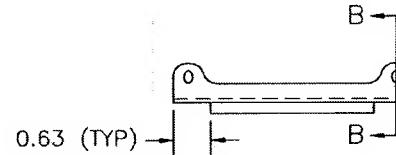
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
DIMENSIONS ARE IN INCHES

NO. 44
WORK ORDER 44
COPY 1
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ALL DESIGN ENGINEERING
RETURN TO DART AEROSPACE USA, INC.

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE O-BROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. REV. D DART AEROSPACE USA, INC. REV. D DART AEROSPACE USA, INC. REV. D
CHECKED	APPROVED	DRAWING NO. D2648 SHEET 1 OF 1 DATE 99.11.17 TITLE WEARPAD SCALE 1:2

RELEASED
12-20-98
D5

COPY
1